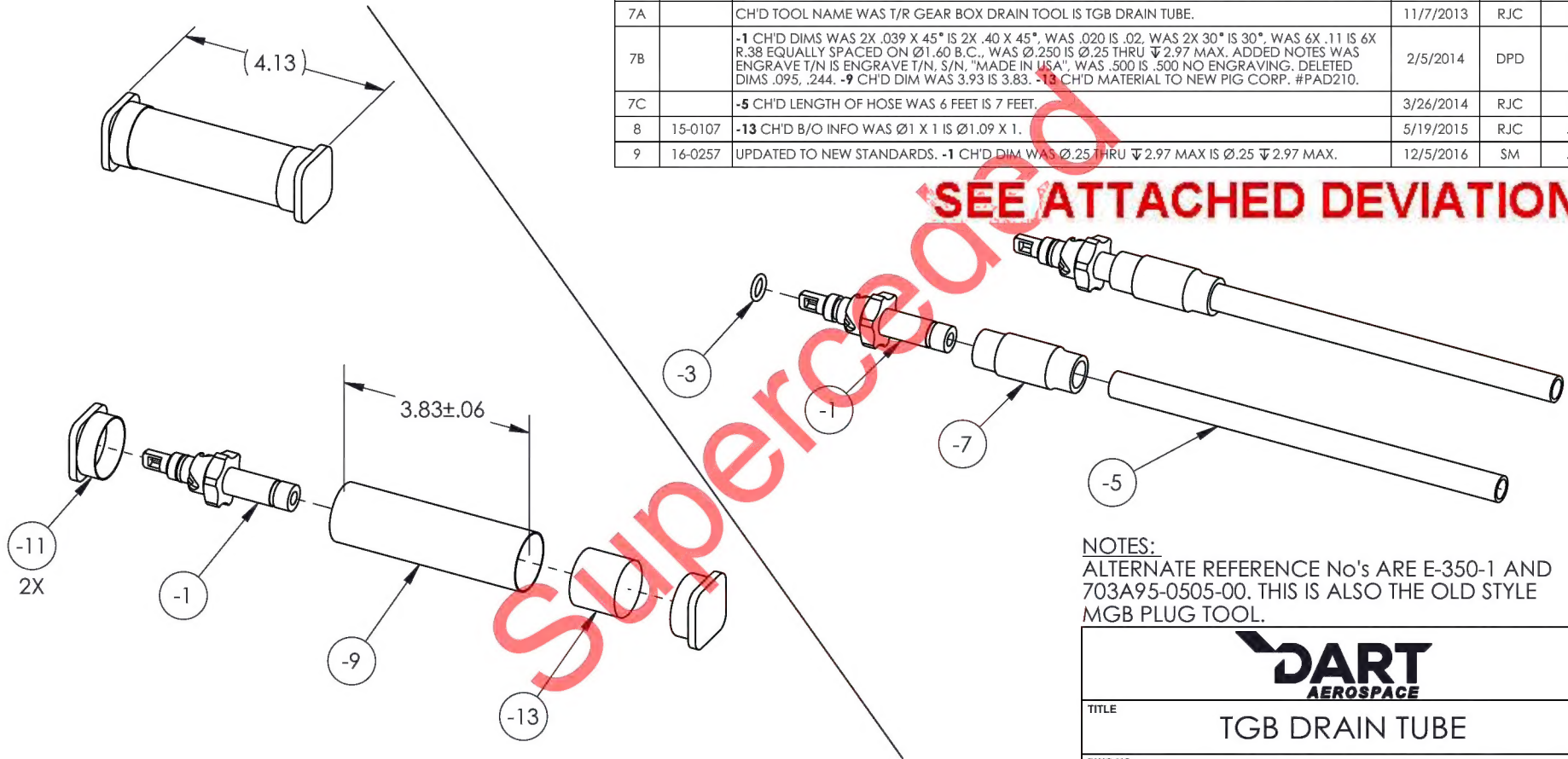


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**UNDER REVIEW**  
URF 19-563 19.02.05 (KPT)



NOTES:  
ALTERNATE REFERENCE No's ARE E-350-1 AND 703A95-0505-00. THIS IS ALSO THE OLD STYLE MGB PLUG TOOL.

<b>DART AEROSPACE</b>	
TITLE <b>TGB DRAIN TUBE</b>	
DWG NO. <b>RBE703A95-0505-00</b>	REV <b>9</b>
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	EUROCOPTER AS-350
APPROVED: GILBERT	
SCALE 1:3	DATE 7/30/2012
SHEET 1 OF 2	

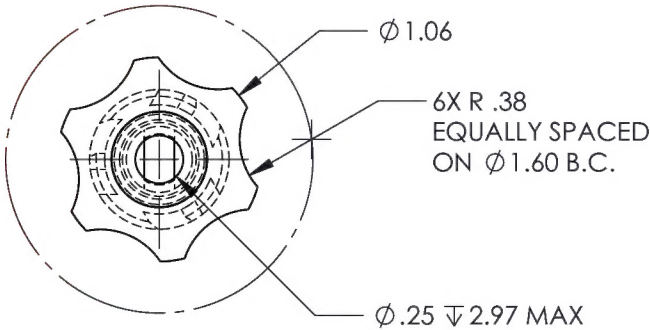
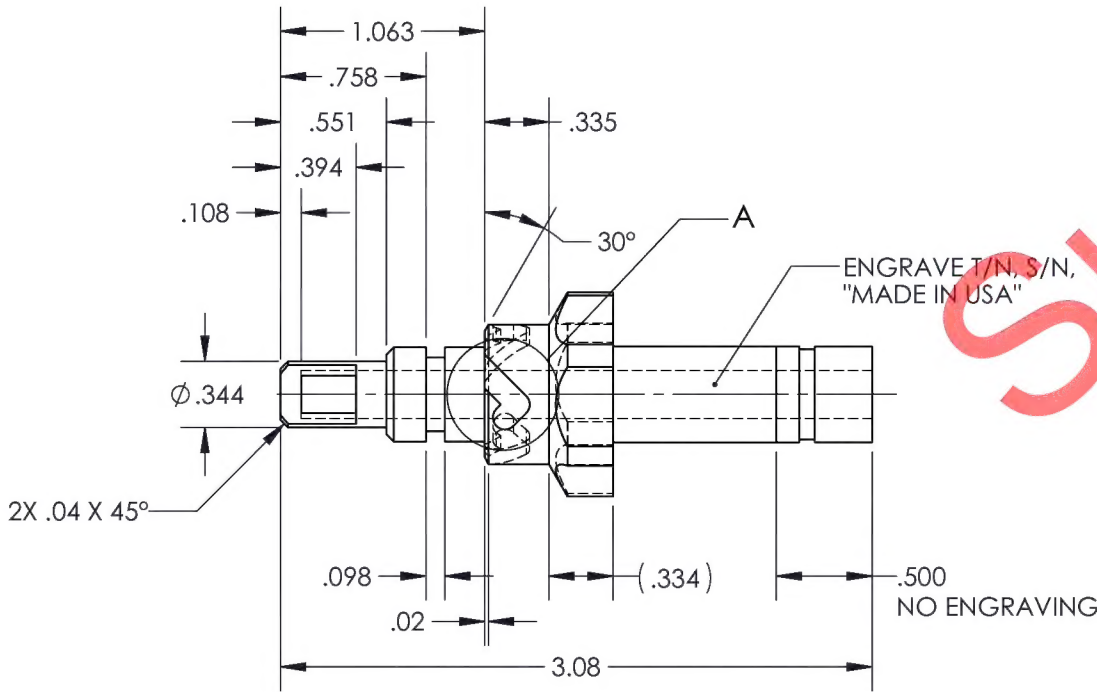
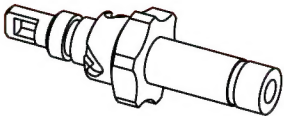
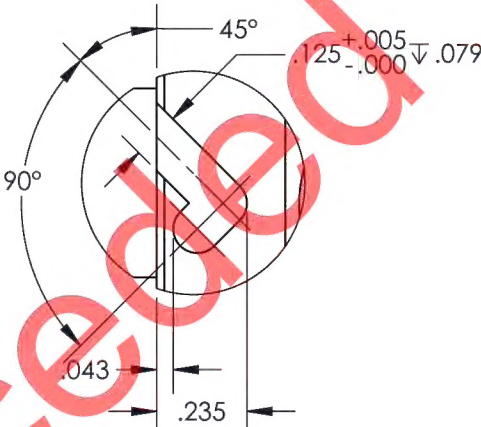
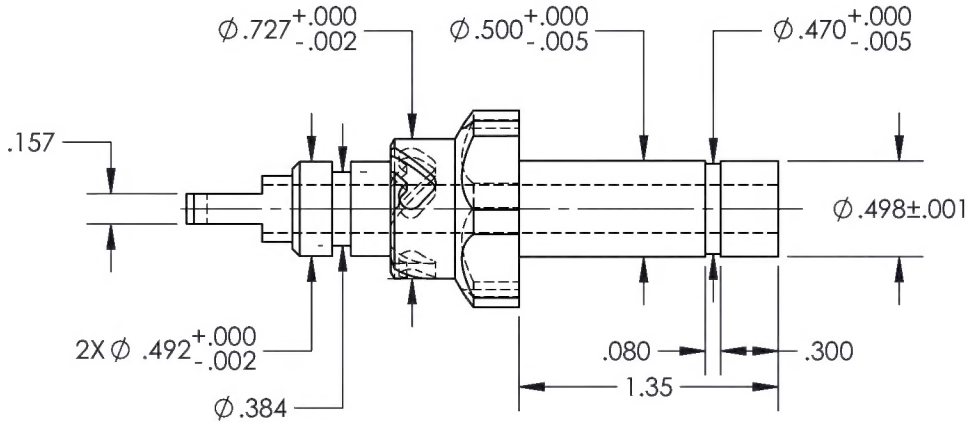
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	Ø1-1/8 X 3-1/8	2
		B/O	-3	1	O-RING	VITON	Ø13mm O.D. x 2mm WIDTH MCMaster-CARR #9263K173	1
		B/O	-5	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 7ft KURI-TECH #K010-0608	1
		B/O	-7	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMaster-CARR #51495K116	1
		B/O	-9	1	TUBE	POLYETHYLENE	Ø1.09 MCMaster-CARR #2044T47	1
		B/O	-11	2	CAP	VINYL	Ø1.09 MCMaster-CARR #2044T67	1
		B/O	-13	1	FOAM	POLYESTER/POLYURETHANE	Ø1.09 X 1 NEW PIG CORP. #PAD210	1

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED O-RING SIZE FROM Ø14.4mm OD x 2.4mm CROSS SECTION. ALSO ADDED NOTES. CH'D SLOTS FROM 90° Ø.131 AND ID FROM .230	5/28/2009	WP	RW
1A		DELETED 49° REF. DIM. FOR -1 PER G.E.	12/16/2010	RJC	RW
2		CH'D ENGAGEMENT SLOT ANGLE FROM 60° TO 90° PER G.E.	3/7/2011	RJC	
3		MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, TUBE, AND CAPS, DELETED HOSE CLAMP AND LABEL. CH'D HOSE FROM Ø5/8 OD TO Ø1/2 OD	7/30/2012	JAG	
4		CH'D 8X R.155 & 8X .121 TO 6X R.375 & 6X .106	4/17/2013	CFS	GE
5		CH'D T/N WAS RBEA95-0505-00-1 IS RBE703A95-0505-00-1. -1 CH'D DIM WAS Ø.125±.079 IS Ø.125 +.005/-0.000±.079. CH'D DIM WAS 6X .106 IS 6X .11. CH'D DIM WAS 6X R .375 IS 6X R .38.	6/19/2013	BIM	RW
7A		CH'D TOOL NAME WAS T/R GEAR BOX DRAIN TOOL IS TGB DRAIN TUBE.	11/7/2013	RJC	RW
7B		-1 CH'D DIMS WAS 2X .039 X 45° IS 2X .40 X 45°, WAS .020 IS .02. WAS 2X 30° IS 30°. WAS 6X .11 IS 6X R.38 EQUALLY SPACED ON Ø1.60 B.C., WAS Ø.250 IS Ø.25 THRU ±2.97 MAX. ADDED NOTES WAS ENGRAVE T/N IS ENGRAVE T/N. S/N. "MADE IN USA", WAS .500 IS .500 NO ENGRAVING. DELETED DIMS .095, .244. -9 CH'D DIM WAS 3.93 IS 3.83. -13 CH'D MATERIAL TO NEW PIG CORP. #PAD210.	2/5/2014	DPD	RW
7C		-5 CH'D LENGTH OF HOSE WAS 6 FEET IS 7 FEET.	3/26/2014	RJC	DW
8	15-0107	-13 CH'D B/O INFO WAS Ø1 X 1 IS Ø1.09 X 1.	5/19/2015	RJC	JAG
9	16-0257	UPDATED TO NEW STANDARDS. -1 CH'D DIM WAS Ø.25 THRU ±2.97 MAX IS Ø.25 ±2.97 MAX.	12/5/2016	SM	JAG

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED O-RING SIZE FROM $\phi$ 14.4mm OD x 2.4mm CROSS SECTION. ALSO ADDED NOTES. CH'D SLOTS FROM 90° $\phi$ .131 AND ID FROM .230	5/28/2009	WP	RW
1A		DELETED 49° REF. DIM. FOR -1 PER G.E.	12/16/2010	RJC	RW
2		CH'D ENGAGEMENT SLOT ANGLE FROM 60° TO 90° PER G.E.	3/7/2011	RJC	
3		CH'D STEM LENGTH FROM .800 TO 1.35, DELETED BARB, ADDED GROOVE.	7/30/2012	JAG	
4		CH'D 8X R.155 & 8X .121 TO 6X R.375 & 6X .106	4/17/2013	CFS	GE
5		-1 CH'D DIM WAS $\phi$ .125 $\pm$ .079 IS $\phi$ .125 +.005/- .000 $\pm$ .079. CH'D DIM WAS 6X .106 IS 6X .11. CH'D DIM WAS 6X R .375 IS 6X R .38.	6/19/2013	BIM	RW
7B		-1 CH'D DIMS WAS 2X .039 X 45° IS 2X .40 X 45°. WAS .020 IS .02. WAS 2X 30° IS 30°. WAS 6X .11 IS 6X R.38 EQUALLY SPACED ON $\phi$ 1.60 B.C.. WAS $\phi$ .250 IS $\phi$ .25 THRU $\pm$ 2.97 MAX. ADDED NOTES WAS ENGRAVE T/N IS ENGRAVE T/N, S/N, "MADE IN USA", WAS .500 IS .500 NO ENGRAVING. DELETED DIMS .095, .244.	2/5/2014	DPD	RJC
9	16-0257	-1 CH'D DIM WAS $\phi$ .25 THRU $\pm$ 2.97 MAX IS $\phi$ .25 $\pm$ 2.97 MAX.	12/5/2016	SM	JAG

SEE ATTACHED DEVIATION



UNDER REVIEW  
URF 19-563 19.02.05 (KPT)

(1)  
QUILL

DART AEROSPACE			
TITLE TGB DRAIN TUBE			
DWG NO. RBE703A95-0505-00-1			REV 9
MAT'L 6061		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8	
FINISH RED ANODIZE		.XX $\pm$ .01 ANGLES $\pm$ 5°	
SPEC MIL-A-8625F, TYPE II, CLASS II		.X $\pm$ .1 SURFACES = 125✓	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		EUROCOPTER AS-350	
SCALE 1:1		DATE 7/30/2012	SHEET 2 OF 2

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. <u>RBE703A95-0505-00 Rev. 9</u>		<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>		<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>				
Date :		Sequence #:		QTY Affected :		<b>MRB (QSI042)</b>  Oct 30, 2018		
<b>Description Work Order Deviation</b>				<b>Disposition</b>				
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)				Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush.  Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).  This deviation is acceptable.  The fit, form and function of the part will be as originally intended.				<b>Completed By</b>
								<b>Lead hand / Supervisor</b>
								<b>QC / QA Coordinator</b>
<b>Root Cause</b>		<b>FAULT CATEGORY</b>						
Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input checked="" type="checkbox"/> X Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		<div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled           </div> <div> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function           </div> <div> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up           </div> <div> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread           </div> </div>						
		Other/Details:						

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